

Work Order ID 64819

Friday, December 17, 2010 8:01:40 AM



Handwritten mark

Page 1

Item ID:	D3639-4	Accept		Setup	Start	
Revision ID:						
Item Name:	Doubler				Stop	
Start Date:	12/16/2010	Start Qty:	6.00			
Required Date:	12/16/2010	Req'd Qty:	6.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:		Date:	10/2-17	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3639	Rev A								
100	FLOW WATER JET	0.00							
	Waterjet								
	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3639		<input type="checkbox"/> Dwg Rev: <u>A</u>	<input type="checkbox"/> Prog Rev: <u>A</u>	<input type="checkbox"/> 2-				
2024.050	Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00							
Quality Control									

B11-1-3

8

Pro →

B11-1-3

17

8/11/10

W/O: 64819		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11/01/03	#120	Took qty +1 for qc inspection template N/A 11.01.03	S	11/01/03	(+1)		S 11/01/03

Part No: D3639-4 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			






NOTE: Date & initial all entries

Work Order ID 64819





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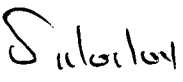


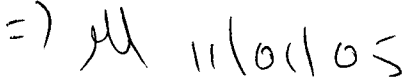

Friday, December 17, 2010 8:01:40 AM

Item ID: D3639-4 Accept  Setup Start 
Revision ID: Stop 
Item Name: Doubler
Start Date: 12/16/2010 Start Qty: 6.00  Cust Item ID:
Required Date: 12/16/2010 Req'd Qty: 6.00  Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start 
Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Brake NC Brake NC	NC BRAKE Memo Form as per Dwg D3639	0.00 0.00							
140  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				 24			
150  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				x7 			

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Work Order ID 64819

Friday, December 17, 2010 8:01:40 AM



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Item ID: D3639-4

Accept



Setup Start



Revision ID:

Item Name: Doubler

Stop



Start Date: 12/16/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 12/16/2010 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

7 BL 11-01-5.

170

Identify as per dwg & Stock Location: 247

0.00



Packaging

Memo

0.00

Packaging

CA/01/06 (7)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 11/01/06

ME 11-01-06

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, December 17, 2010 8:01:44 AM

Page 1

Work Order ID: 64819



Parent Item: D3639-4



Parent Item Name: Doubler

Start Date: 12/16/2010

Required Date: 12/16/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-07-20 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.050		Purchased	No			100	sf	92.3847	0.4277	2.701263			



2024-T3 .050 sheet



BH-1.3

Location

Loc Qty

Loc Code

MAT22

92.3847

111381

11.89

113189

0.3947

114968

80.1

114968

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	44819
Description: Doubler		Part Number:	D3639-4
Inspection Dwg: D3639 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.625	+0.008/-0.001	.625	✓		V HB02	
Ø0.191	+0.005/-0.001	.191	✓		V	
Ø0.098	+0.004/-0.001	.098	✓		V	
0.45	+/-0.030	.454	✗		V	
1.350	+/-0.010	1.353	✗		V	
2.25	+/-0.030	2.253	✗		V	
3.15	+/-0.030	3.162	✓		V	
4.05	+/-0.030	4.055	✓		V	
4.95	+/-0.030	4.957	✓		V	
5.85	+/-0.030	5.855	✓		V	
6.7	+/-0.030	6.750	✓		V	
7.65	+/-0.030	7.655	✓		V	
8.55	+/-0.030	8.555	✓		V PRO HB2	
9.350	+/-0.010	9.356	✗		V PRO HB2	
9.45	+/-0.030	9.455	✓		V PRO HB2	
10.350	+/-0.010	10.352	✗		V PRO HB2	
11.25	+/-0.030	11.252	✓		T HB01	
12.15	+/-0.030	12.15	✗		T	
12.85	+/-0.030	BEND			T	
13.86	+/-0.030	13.86	✗		T	
13.96	+/-0.030	13.96	✓		T	
0.805	+/-0.010	.805	✓		V	
1.00	+/-0.030	1.004	✓		V	
2.100	+/-0.010	2.098	✗		V	
3.30	+/-0.030	3.307	✓		V	
2.000	+/-0.010	2.000	✓		V	
2.590	+/-0.010	2.587	✓		V	

Measured by: HB	Audited by: S	Prototype Approval:	N/A
Date: 11-1-3	Date: 11/01/03	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.10.24	New Issue	KJ/EC/DD	DS

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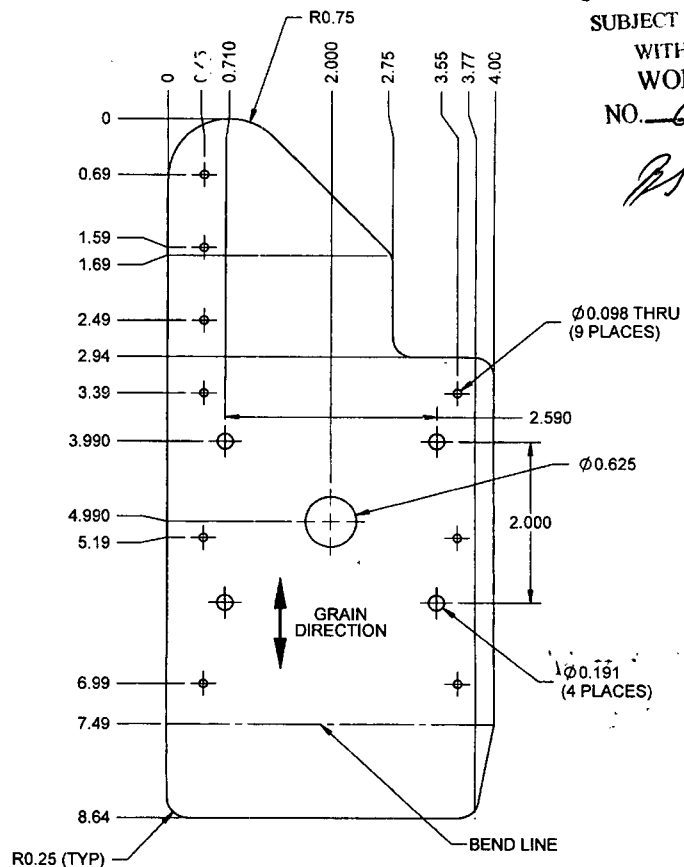
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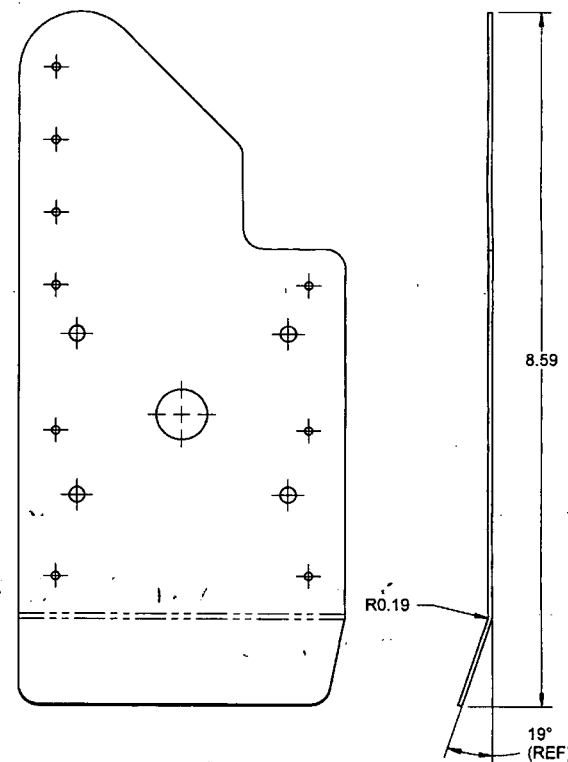
NOTE: Date & initial all entries

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RETURN TO
ENGINEERING

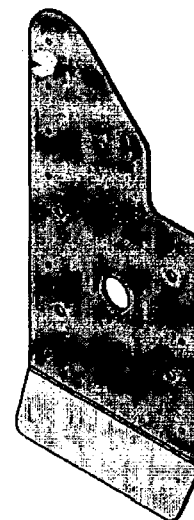
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 64869
25-01-17



D3639-1F FLAT PATTERN
(D3639-2F OPPOSITE)



D3639-1 DOUBLER
(WAS GENEVA P/N G10604-3)
D3639-2 OPPOSITE
(WAS GENEVA P/N G10604-6)



RELEASED
07-07-07

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3639-1/-2" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.14 lbs

A	NEW ISSUE; REPLACES G10604		LE	07.07.27
REV.	DESCRIPTION		BY	DATE
DESIGN	TS	DART AEROSPACE USA, INC. PORT HADLOCK, WA		
DRAWN	CE			
CHECKED	B	DRAWING NO.	REV. /	
MFG. APPR.	E	D3639	SHEET 1 OF	
APPROVED	NO	TITLE	SCALE	
DE APPR.	1	DOUBLER	2:	
DATE	07.07.27	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.		

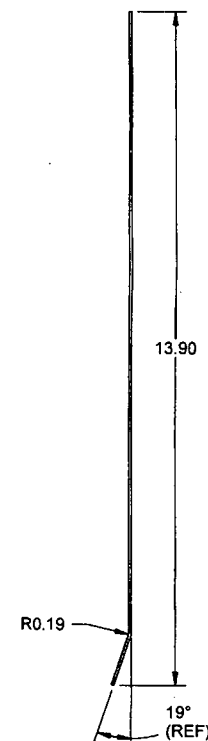
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D3639-3 DOUBLER
(WAS GENEVA P/N G10604-4)
D3639-4 OPPOSITE
(WAS GENEVA P/N G10604-5)

RELEASED
07.09.07 #

7) WEIGHT: 0.3 lbs

DESIGN	TS	DART AEROSPACE USA, INC.	
DRAWN	CE	PORT HADLOCK, WA	
CHECKED	TS	DRAWING NO.	REV. A
MFG. APPR.	CE	D3639	SHEET 2 OF 2
APPROVED	TS	TITLE	SCALE
DE APPR.	TS	DOUBLER	2:1
DATE	07.07.27	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS COVENANT THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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